0.00 120 QC2-Inspect parts off machine FAI/FAIB

\*120\* 0.00 QC<sup>§</sup>

Memo Quality Control

10 U Au

										DQA:	Date	e:	
NCR: Ye	es / No				WORK ORDER NON-	CON	IFORI	MANCE / UP	DATE	QA Closed:	Date	e:	
, Work Order	·				DISPOSITION				AGAINST DE				
Part No	o			ANNO SERVICE	Rework Scrap Use-as-is Work Order Update	Machining Small Fab Prod. Eng. Coor. Qual						Engineering Quality Other	
Root	1	1		Descri	ption of work order update		nitial	Ac	tion	Sign &			
Cause	Date	Step	Qty	•	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector	
oc/Data quip/Tooling Operator Material Setup Other Process Supplier													
raining	1												
Jnapproved													
					!	FAUL	T CATE	GORY					
Landin	g Gear				General		_			_	_		
·	Bending Centre N Cracks	ot Conce	ntric to (	o/s	Bend BOM/Route Broken/Damaged		Grain Hardwa Inspecti	re on Incomplete		Ovalized Over/Under Part Incorred	<b> -</b>	Pressure/Forced Temperature/Cure Weld	
	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs				Contamination		Mainte	enance		Part Moved	_	<del></del>	
	Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong	_	
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other	
	Ripples in	n Bend			Drill Holes		Offset						
	Torque V	Vaves in I	Extrusio	n _	Drawing		Out of	Calibration					
	Turning S	Sequence	<b>!</b>		Finish		Out of 9	Sequence					
	Wave/Tv	vist in Tul	be		Folio		Outside	Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work	Order	ID	107234
<u> </u>			

\*107234\*

Page 2

September-23-13	11.30.09 A	(VI								
Revision ID:	646.3910 Shim			Accept	*N900	<b>04010</b>	) <b>()</b> *	Setup Star	ı Vı .	S1* S2*
₹	9/23/13	Start Qty: 6.00 Req'd Qty: 6.00	• •		Cust Item I Customer:	D:		-	IV.	
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:	]  	Run Star Stop		R1* R2*
Sequence ID/ Work Center ID 130 *130*	)	Operation Description QC8- Inspect parts -	second check	Set Up/ Run Hours 0.00 27 9-89	Tool ID	Tool # Plar Cod	-	Reject Qty	Reject Number	Insp. Stamp
QC Quality Control		Memo		0.00 13 11 (	24					,
¹ <sup>140</sup> <b>*1∆∩</b> *		Outsource process-C	adplate per QSI017 4.1.				CX	13/11/0	06_(1	(o)
Outsource process - (	Cad plate	Memo Issue P/	o: <u>21961</u>	0.00						
*150*		Receive & Inspect for	or Damage & Mat'l Certs	0.00			10x		7 13-	12-4.
Packaging Packaging		Memo		0.00						·/-

DAS 26 9-89

NCR:	Yes	1	No
NCN.	162	,	INU

										DQA:	Date	2:	1		
NCR: '	Yes	/ No					WORK ORDER NON-C	201	NFORM	MANCE / UF	PDATE	QA Closed:	Date	2:	
Vork Ord	er:						DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	•	
Part I	No.		, <u>.</u>				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	<b>⊣</b>	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Des		otion of work order update	1	nitial		ction	Sign &	N- ifi - Ai	061	_
Cause oc/Data quip/Tooling perator laterial etup ther rocess upplier raining napproved		Date	Step	Qty		O	or Non-conformance	·	hief Eng Description			Date	Verification	QC Inspector	
			<b>.</b>				F	AUL	T CATE	GORY					
Land	ing (	Gear Bending					General Bend		•	<u> </u>		Ovalized	Γ	Pressure/Forced	
	Centre Not Concentric to O/S Cracks Broken/Damaged Burrs Cuffs Contamination Countersink Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing					Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Temperature/Cure Weld Wrong Stock Pulled Other				
	Turning Sequence						Finish	Out of Sequence							

Outside Dimensions

Wave/Twist in Tube

Folio

Work Ord September-23-				*10			Page		
Item ID: Revision ID: Item Name:	646.3910 Shim			Accept	*N900040100*	Setup	Start Stop	*NS1*	
Start Date: Required Date Reference:	9/23/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item ID: Customer:			14(1)	
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):	Date: Date:	Run	Start Stop	*NR1*	

\*NR2\* Tool ID Tool # Plan Reject Reject Accept Insp. Sequence ID/ Operation Set Up/ Number Stamp Run Hours DAS Code Qty Qty Work Center ID Description 0.00 QC5- Inspect part completeness to step on W/O 160 \*160\* Memo

170	Identify as per dwg & Stock Location: 51535	0.00
*170* Packaging	Memo	0.00
Packaging	***IDENTIFY AS PER APICAL MPP-12	0 BY STAMPING THE P# AND

Page 3

OC21- Final Inspection - Work Order Release 0.00 \*120\*

Memo

REV\*\*\*

0.00

Quality Control

Quality Control

OC

13/12/94

										DQA:	Da	te:		
NCR: Y	es / No				WORK ORDER NON-C	ON	NFORM	MANCE / UPDATE		QA Closed:	 Da	te:	,	
Mark Onda					DISPOSITION			AGAINST D					4	
Work Orde  Part N  NCR N	No.				Rework Scrap Use-as-is Work Order Update		l Therm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite	Small Fab Prod. Eng. Coor. Finishing Rec/Store/Packaging Composite Supplier					
Root				Descri	ption of work order update	1	nitial	Action		Sign &				
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description		Date	Verificatio	n	QC Inspector	
Doc/Data		Ī							Ţ					
Equip/Tooling						ļ								
Operator		İ				1								
Material												l		
Setup												l		
Other														
Process						İ						1		
Supplier												Ì		
Training												ı		
Unapproved						<u> </u>								
					F	AUL	T CATE	GORY	_		, <del></del>			
Landi	ng Gear				General									
	Bending				Bend		Grain			Ovalized		Ш	Pressure/Forced	
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ıre		Over/Under	tolerance		Temperature/Cure	
	Cracks				Broken/Damaged		Inspect	ion Incomplete	$\_$	Part Incorre	ct	Ш	Weld	
	Crushed	/Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	issing		Wrong Stock Pulled	
	Cuffs				Contamination		Mainte	enance		Part Moved				
	Heat Tre	at		Γ	Countersink		Mislabe	eled		Positioned V	Vrong			

Misread

Out of Calibration
Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio **Picklist Print** 

September-23-13 11:36:08 AM

Work Order ID:

107234

Parent Item:

646.3910

Parent Item Name:

Shim

**Start Date:** 9/23/13

Required Date: 9/23/13

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV:A 12.12.23 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
1C1095S.020 1095 Blue Tempered Spi	ring Steel Sheet .020	Purchased	No			110	sf	28.4000	0.03	<del>-0.189473</del>	<b>7</b> -	Au	13.11
	•			Location		Loc Qty	Lo	c Code					
				MAT022		28.4							
				123	537	5.4				<u> </u>	<b>-</b>		21
				m12	26423	23			10	1641	5 -	<del>&gt;</del>	101

NCR: Ye	es / No				WORK ORDER NON-C	CON	FORM	ANCE / UP	DATE			d g
18111	!									QA Closed:	Date:	<u> </u>
Work Orde	r:				DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
					Rework	] [		Skid-tube	Crosstube		Water Jet	Engineering
Part N	o				Scrap		ſ	Machining	Small Fab	<b>⊣</b>	d. Eng. Coor.	Quality
	i				Use-as-is	╛		noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	0				Work Order Update	]		Large Fab	Composite	_	Supplier	
Root	T			Descri	ption of work order update	In	nitial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data	-						,					
quip/Tooling												
Operator		1				1				1		
Material	_						:					
etup	_											
Other	_	İ										
Process												
Supplier					·	1						
raining	_							<u> </u> 				
Jnapproved												
					<del></del>	AUL	CATE	GORY				*****
Landin F	ng Gear				General		<u>.</u>		_	ا ما الم	_	Pressure/Forced
-	Bending			_	Bend	1	Grain		<u> </u>	Ovalized Over/Under		Temperature/Cure
}	Centre N	ot Conce	ntric to	O/S  -	BOM/Route		Hardwa		-	Part Incorre	<b></b>	Weld
}	Cracks	/a :		<u> </u>	Broken/Damaged	—	•	ion Incomplete	Linelana –	Part Incorre	·	Wrong Stock Pulled
	Crushed/	Crimpea		ļ	Burrs	-		ions Incomplete/	Unclear	Part Moved	issing	I wrong Stock Pulled
}	Cuffs			-	Contamination	$\vdash$		enance	-	<b>⊣</b>	M	
-	Heat Tre		Tuba	-	Countersink	$\vdash$	Mislabe		-	Positioned V		Other
	Inspection	-	ııupe		Cut Too Short Drill Holes	$\vdash$	Misread Offset	ı		Trower ross/	ourge	Totalei
	Ripples in	n Bend Vaves in I	F	_	╡	$\vdash$		Calibration				
	Turning			" ├	Drawing	$\vdash$		Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

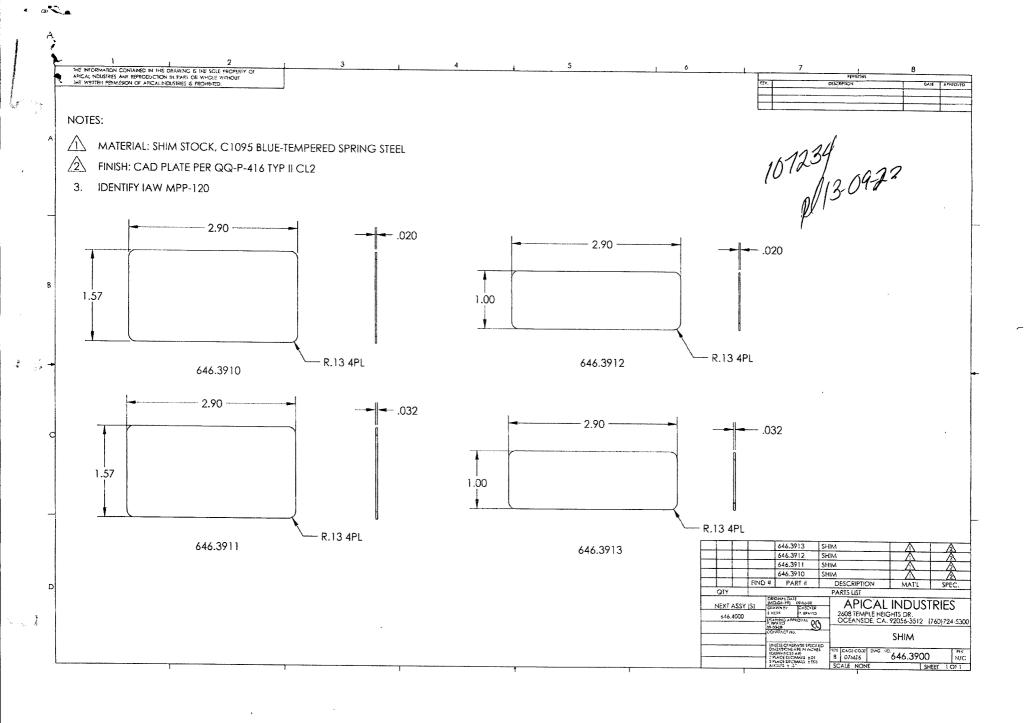
DART AEROSPACE LTDWork Order:/0723 4Description: ShimPart Number:646.3910Inspection Dwg: 646.3900Rev: N/CPage 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.57	+/-0.005	1.57"	_		V	JKW-01
2.90	+/-0.005	1.57" 2.90"	-		V	O F III
0.020	+/-0.005	1020"			v	
			DAS			

·				DAS		
	Measured by:	Ac	Audited by:	27	Preliminary Approval:	
	Date:	13.11.00	Date:	R 11 04	Date:	
					-	

[	Rev	Date	Change	Revised by	Approved
. [	Α .	12.11.30	New Issue	KJ S	
_					



## **GERTIFICATE OF** CONFORMANCE

GADORATH-PLATING CO. LTD., 🝅 2150 LOGAN AVENUE WINNIPEG, MANITOBA R2J-0J1

DATE:

Dec-02-2013

CONSIGNED TO: Dart Aerospace Ltd.

1270 Aberdeen St.

Hawksbury, ON K6A 1K7

W/O #:

130246

**INVOICE #:** 

68742

**CONTRACT OR** 

**PURCHASE ORDER #** 

PO21961

DESCRIPTION:

SHIM

QTY

10

P/N# 646.3910

S/N # 107234

CADMIUM PLATING IAW AMS-QQ-P-416C TYPE 2 YELLOW CLASS 2. BAKE HEAT CHART # 13-1051.

CERTIFICATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.

**Approved Inspector:**